

Date: Monday, 22/12/2008 3:06:03 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RIGHT ARM WELDMENT
Job Number :	44248		
Estimate Number :	12113		
P.O. Number :		Part Number :	D335311
This Issue :	22/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3353 REV.A
First Issue :	/ /	Project Number :	N/A
Previous Run :	34675	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>TUD 08.12.23</u>	Due Date :	20/01/2009
Comment :	est rev. A 06.01.25 new issue EC	Qty:	20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B1500X01500	MILD STEEL BAR 1.50 X 1.50
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Comment: Qty.: 0.2100 f(s)/Unit Total: ~~2.1000~~ f(s)

1010-1025 BAR 4.200

AISI 1010-1025 Steel bar 1.50" x 1.50" Batch: M109616

RAD ON STOCK BAR
 ACCEPTABLE THIS W/O

09.01.08

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 2.375" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA619 and Dwg D3353

2-Chamfer large hole manually per dwg D3353

2- Deburr

mmf 09/01/08

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/01/08

(20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mmf 09/01/08

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RIGHT ARM WELDMENT

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Part Number: D335311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

57490

9/01/09

(20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20
2096/09

Job Completion



mf 09-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

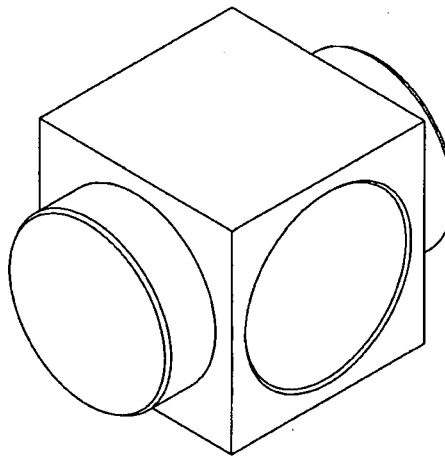
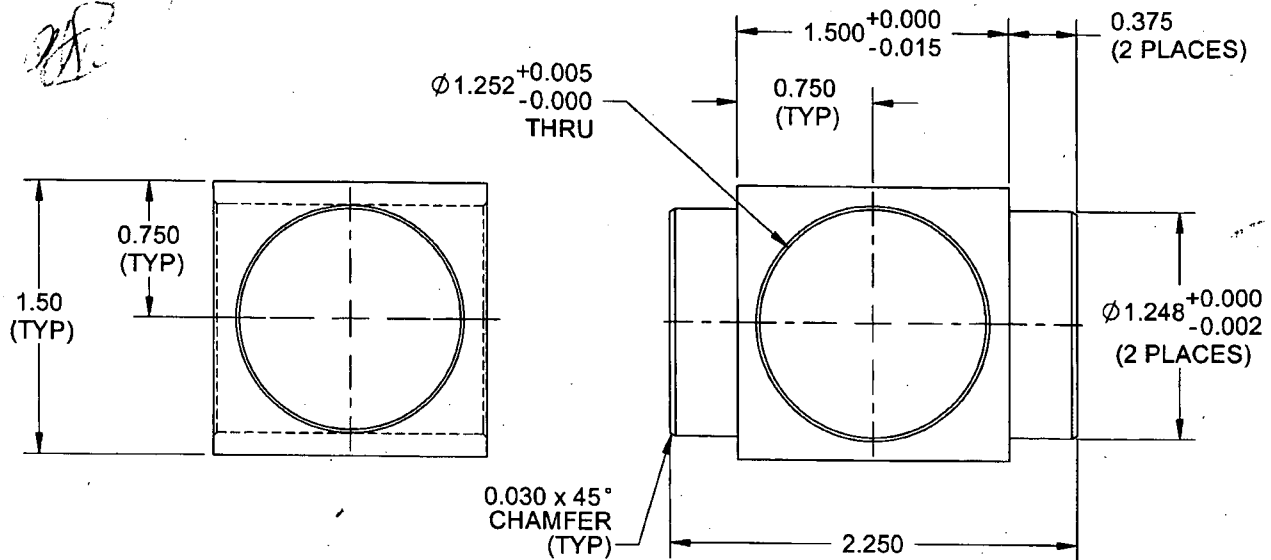
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 8 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
04/33/07**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46248

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